

Work Order ID 67526 -1

Monday, March 28, 2011 9:06:39 AM

Split



Page 1

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 3/28/2011 Start Qty: 12.00

Required Date: 3/31/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 11-03-25 Fooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	Rev B								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3319								
1010 .050	Dwg Rev: 8								
	Prog Rev: B								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B11-3-28

15

B11-3-28

15

8 u103/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67526

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Page 2

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Brake NC

NC BRAKE

0.00

Memo

0.00

1- Form using DT8326 & DT8261 as per Dwg D3319Rev: 5

2- Form flat on press using DT8776 block

150



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

160



Large Fab

Large Fab

Weld per dwg A/R Hardcoat steel Batch:

0.00

Large Fab

Memo

0.00

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: _____

Qty	Part Number	Description	Batch
A/R	N/A	228/7560 Hardcoat Rod	<u>B</u>

15

45

11-4-5 X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 67526

Monday, March 28, 2011 9:06:39 AM



Page 3

Item ID: D3319-1	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Wearplate				
Start Date: 3/28/2011	Start Qty: 12.00		Cust Item ID:	
Required Date: 3/31/2011	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		<i>8 u/4/06</i>					
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>8 u/4/06</i>		<i>(+3)</i>			
190 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 115128</i> Memo START TIME: <i>11:15</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:45</i>	0.00 0.00				<i>3</i>	<i>BL 11-4-6</i>		

W/O:		WORK ORDER CHANGES						
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Work Order ID 67526

Monday, March 28, 2011 9:06:39 AM



Page 4

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/4/08

210

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX
For Product Eligibility see PDA05-18
and Stock
Location: _____

11/4/08 30

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/08

mf

11-04-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 9:06:44 AM

Page 1

Work Order ID: 67526

Parent Item: D3319-1

Parent Item Name: Wearplate





Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA  1010/1025 SHEET .048		Purchased	No			100	sf	120.0000	0.628 	7.932632	95 1811-3-28		

Location

Loc Qty

Loc Code

MAT019

120

116268

120

116268

15

W/O:		WORK ORDER CHANGES						
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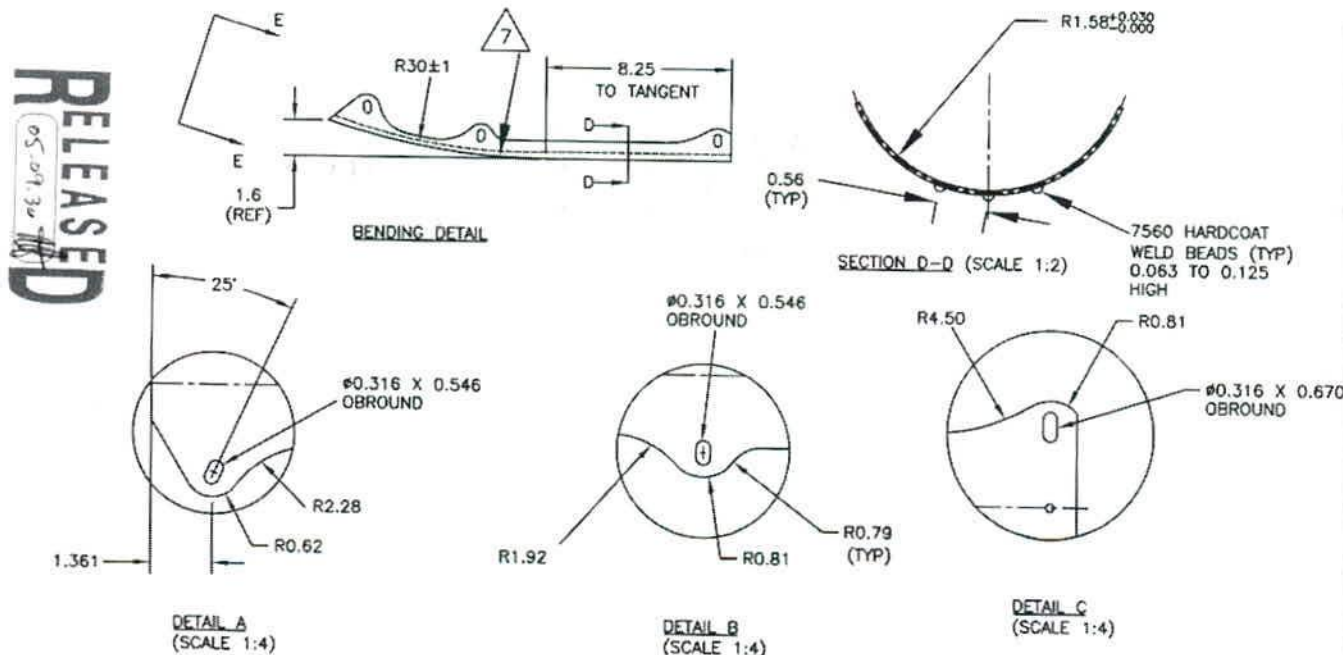
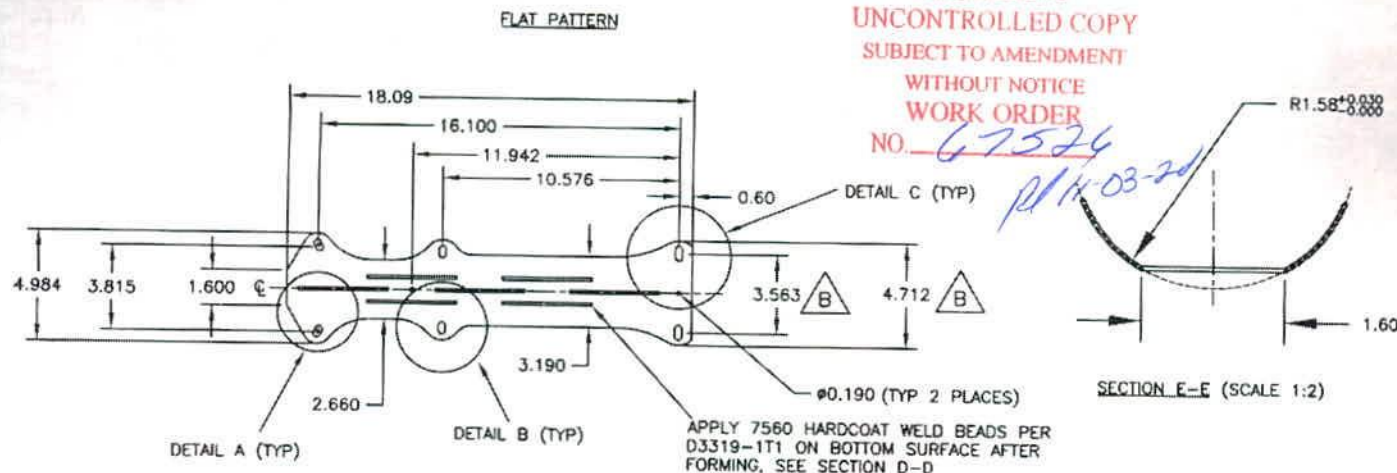
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67524
P/H-03-20

DART



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
H1	H1	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
H1	H1	D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
A	NEW ISSUE	REV. B
04.09.24	NEW ISSUE	SHEET 1 OF 5
B	WIDEN HOLES, REDUCE WIDTH -3/-5/-7	SCALE
05.06.06		1:8

RELEASED
05.09.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

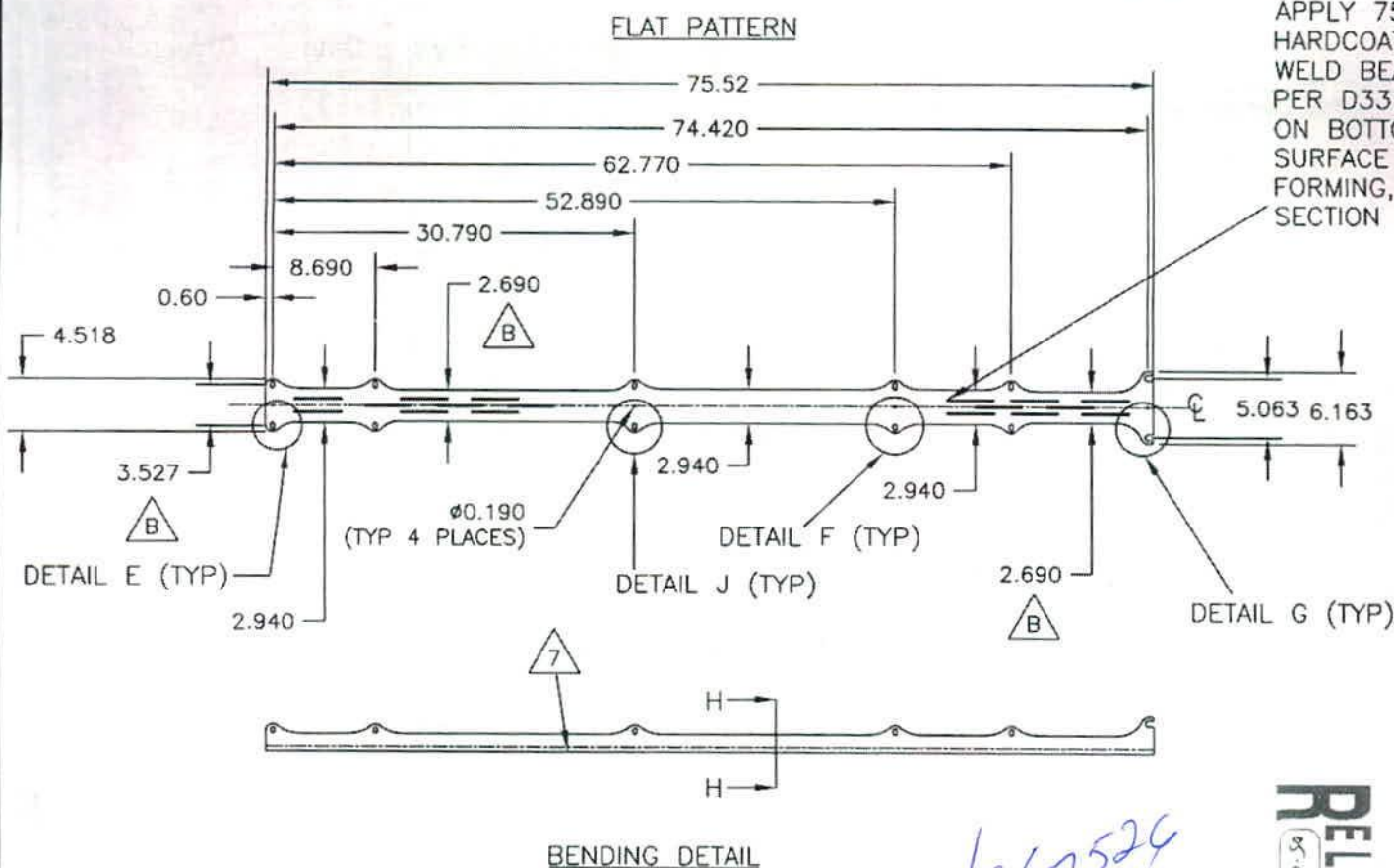
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	APPROVED	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE		TITLE	REV. B
05.06.06		WEARPLATE	SHEET 2 OF 5
			SCALE
			1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05.07.30

w/047524

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

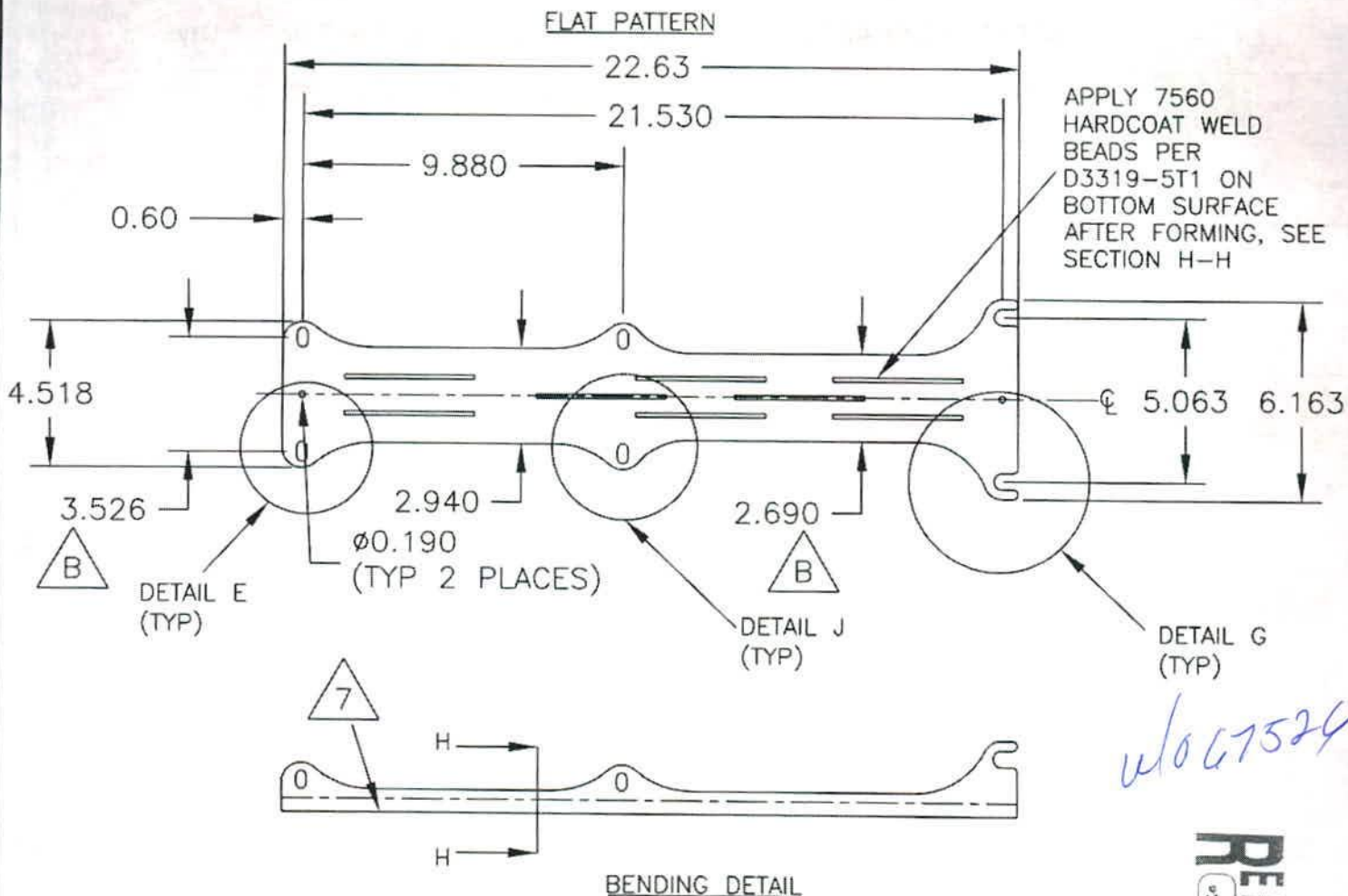
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA	
DRAWN BY	REV. B	
CHECKED	DRAWING NO.	SHEET 3 OF 5
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:5



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05-09-30
APR

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ONTARIO, CANADA

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3319

REV. 8
SHEET 4 OF 5

DATE _____

05.06.06

CHECKE

APPROVED

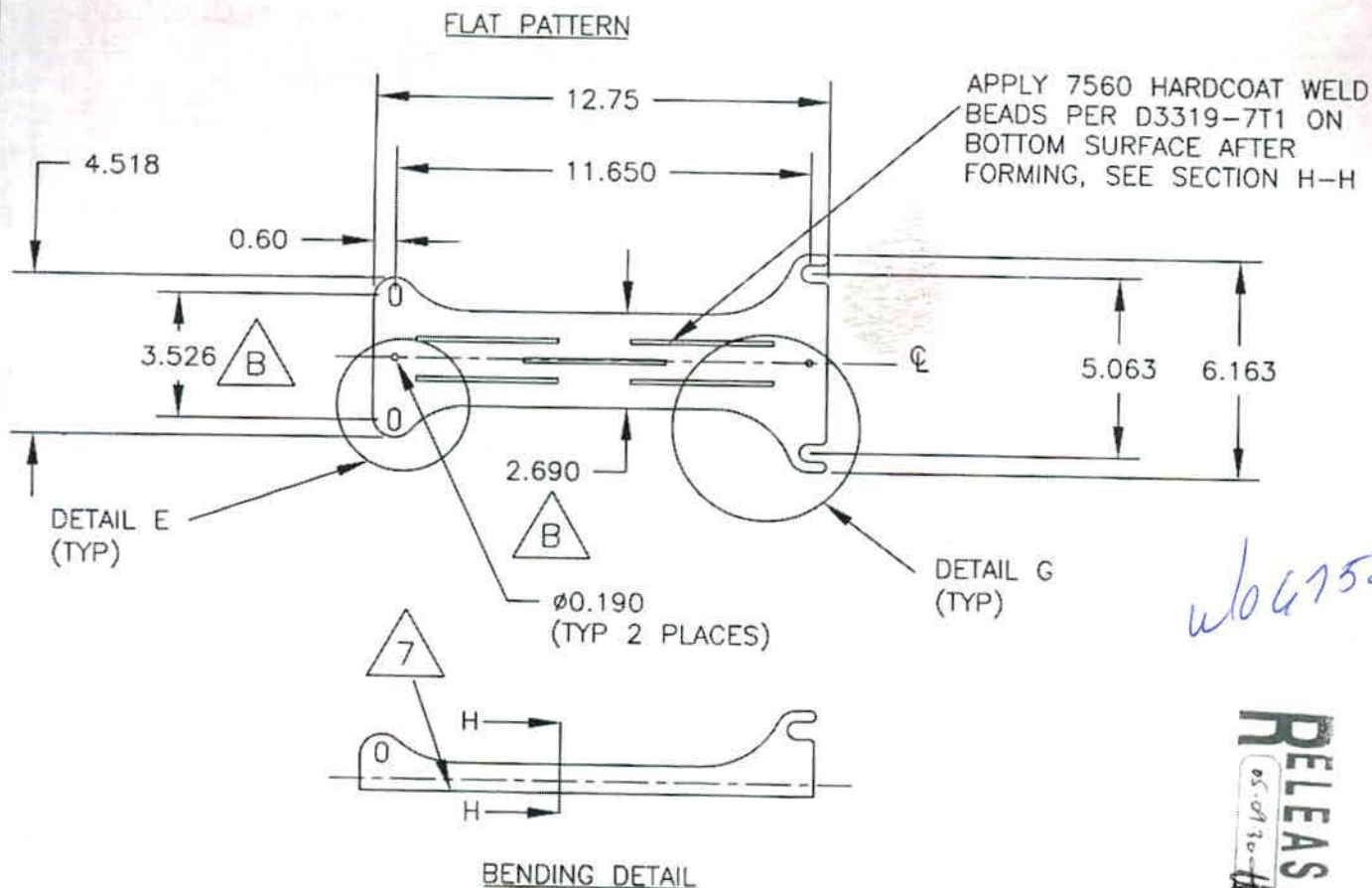
DRAWING NO.

D5319

SHEET 4 OF 5

WEARPLATE

1:5



05-0930-11

D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
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- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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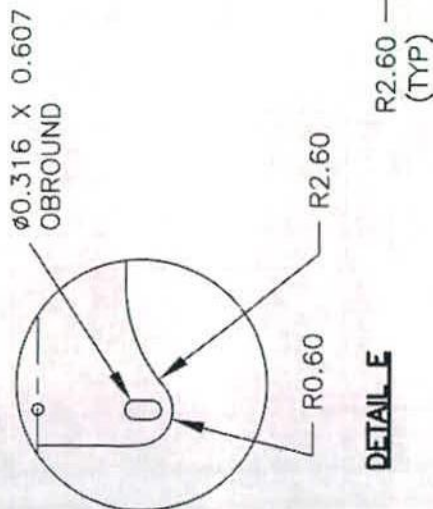
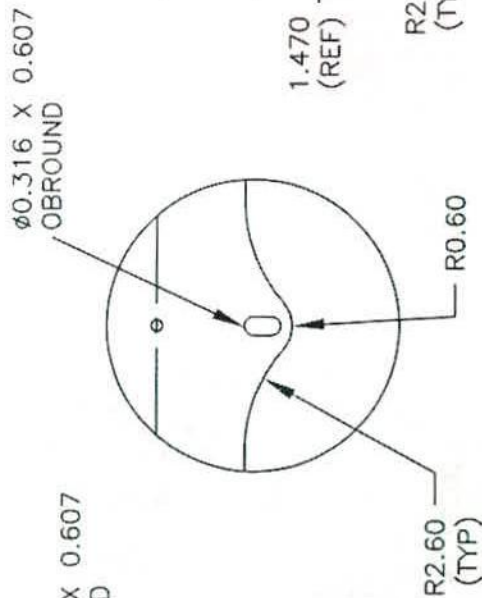
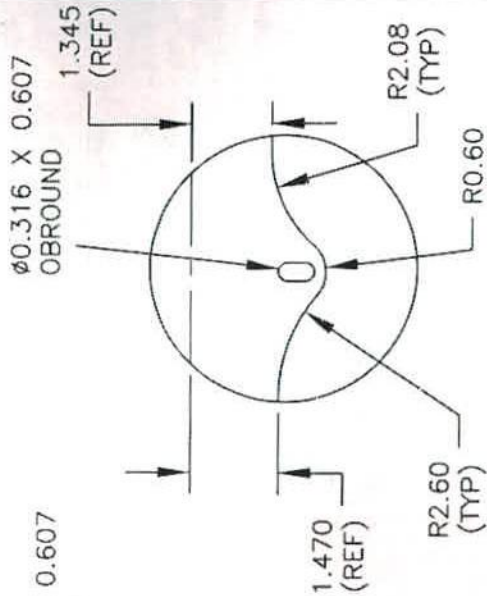
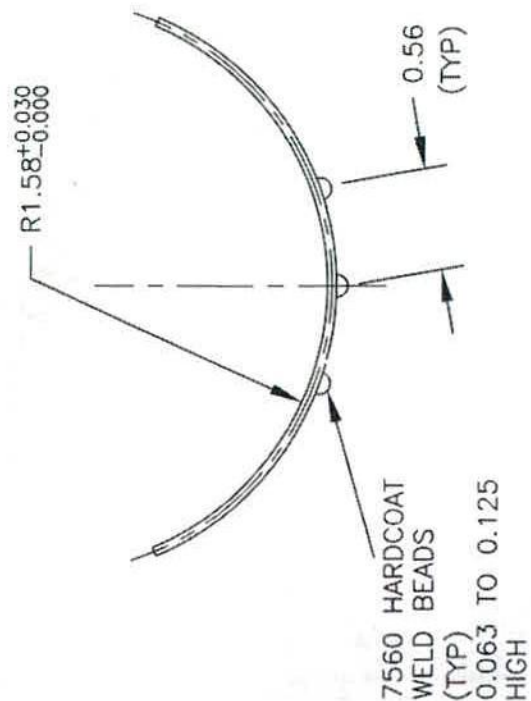
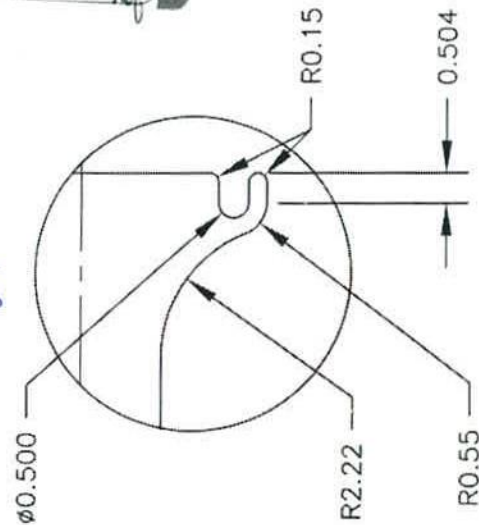
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DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

**RELEASED**
05 09 30*W667526*

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